



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5090-3

Job Sheet 168439



Part No: D5090-3

Job Qty: 30 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/14/17

Job Tracking No:

Due Date: 12/5/17

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV C U/R SHEETS 3,4,5 IPP REV:A 14.06.18 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	30 Ea		12/5/17	0.00	0.00	Start Up Waterjet		SC
100	Waterjet	30 pcs		12/5/17	0.00	2.98	Waterjet1		SC DAS
120	QC	30 pcs		12/5/17	0.00	0.00	QC8		38
130	Brake NC	30 pcs		12/5/17	0.00	1.55	Brake NC 2		38 DAS
140	QC	30 pcs		12/5/17	0.00	0.00	QC5		38
150	HandFinish	30 pcs		12/5/17	0.00	1.78	HandFinish1		38 12/12/14
160	QC	30 pcs		12/5/17	0.00	0.00	QC7		38
170	QC	30 pcs		12/5/17	0.00	0.00	QC5		38
180	Packaging	30 pcs		12/5/17	0.00	0.00	Packaging3		38
200	QC21-SA	30 Ea		12/5/17	0.00	0.00	QC21		38

Part Op Descriptions: 100 - 1-Cut as per Dwg Prog Rev: D 2-Deburr as required

DEC 14 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6S.040 5010884	21	185	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	0.129Inches + 0.005 - 0.001	0.134 0.128	Diameter	
2	Bracket	0.840Inches ± 0.030	0.870 0.810		
3	Bracket	0.520Inches ± 0.030	0.550 0.490		
4	Bracket	0.375Inches ± 0.010	0.385 0.365		
5	Bracket	0.875Inches ± 0.010	0.885 0.865		
6	Bracket	0.790Inches ± 0.030	0.820 0.760		
7	Bracket	0.950Inches ± 0.030	0.980 0.920		
8	Bracket	4.620Inches ± 0.030	4.650		

DART
AEROSPACE
S019444



Bracket

PART NO:
Revision:
Operation:
Change No:

D5090 - 3

Start up Operation

Mfg Date: 12/10/17
Job No: 168439

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

			4.590
9	Bracket	5.580Inches $\pm$ 0.030	5.610 5.550
10	Bracket	17.540Inches $\pm$ 0.030	17.570 17.510
11	Bracket	0.040Inches $\pm$ 0.030	0.070 0.010

Plex 11/30/17 3:43 PM dart.poulin.mario

